








Work Order ID 53469




November 6, 2009 8:38:26 AM

Page 1

Item ID: D3815-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Web Assembly
Start Date: 05/11/2009 Start Qty: ~~10.00~~ ¹³  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: PS Date: 09-11-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3815	Rev A								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- install rivets as per dwg D3815								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

PS 09/12/21 (13)

PS 09/12/21 (13)

PS 09/12/22 13

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Reference:

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32

[illegible]

Abstract

Customer:



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

15

Stamp
65-12-22

0.00

0.00

Page 22 (13)

0,00

0.00

09.12.23

C209/12123

Picklist Print

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Work Order ID: 53469

Parent Item: D3815-041RevA

Parent Item Name: Web Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN526C832R14

Purchased

No



Screw

110
150
09/12/22

935.0000 40.0000



09/12/21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

935

104916

935

53

D3815-1RevA

Manufactured

No



Angle

110

Each

0.0000

10.0000

B53894 (13x)



09/12/21

D3815-2RevA

Manufactured

No



Angle

110

Each

5.0000

10.0000



09/12/21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

45834

5

5

D3815-3RevA

Manufactured

No



Web

110

Each

3.0000

10.0000



09/12/21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

45835

3

3

B52928 (10x)

Picklist Print

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Work Order ID: 53469

Parent Item: D3815-041RevA

Parent Item Name: Web Assembly


Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-6  Rivet, Universal Head		Purchased	No			110	Each	1,652.000	250.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1652

109371

64

110915

73

112492

1515

MS21042L08

Purchased

No



Nut

Each

260.0000

40.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

260

110002

24

111889

30

112243

47

112492

24

112612

35

112794

100

NAS1149DN3225

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Shop Packet Print

Page 2

11/09/12/22

Seq 150

Batch: M112385 x52

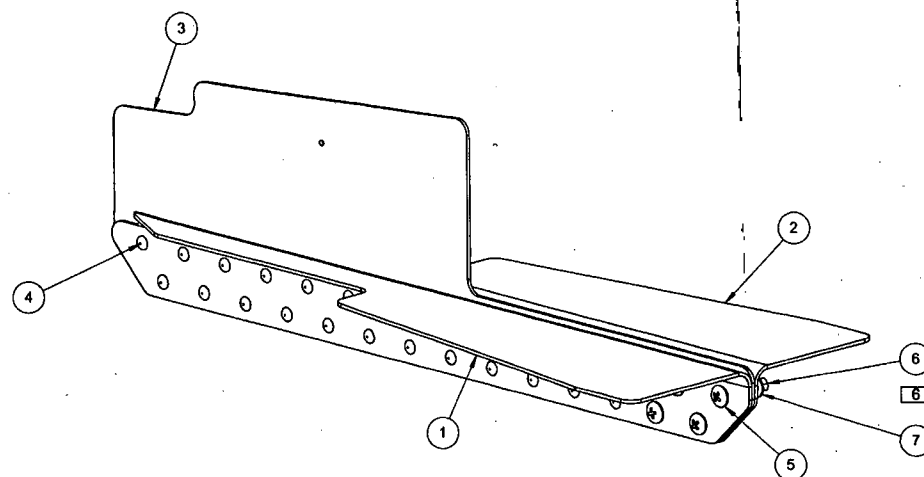
M113149 (29X)

11/09/12/21

11/09/12/21

325
11/09/12/21

24



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

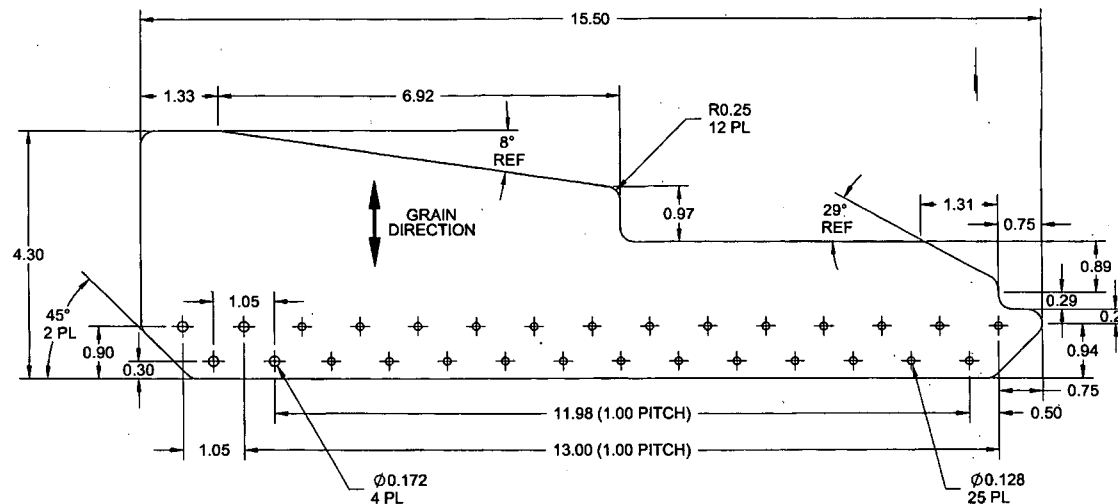
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53449
09-11-5

RELEASED
09/07/13

- NOTES:
- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
 - 5) WEIGHT: 0.88 lbs
 - 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A	NEW ISSUE		08.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3815	REV. A SHEET 1 OF 5
TITLE WEB	SCALE NTS
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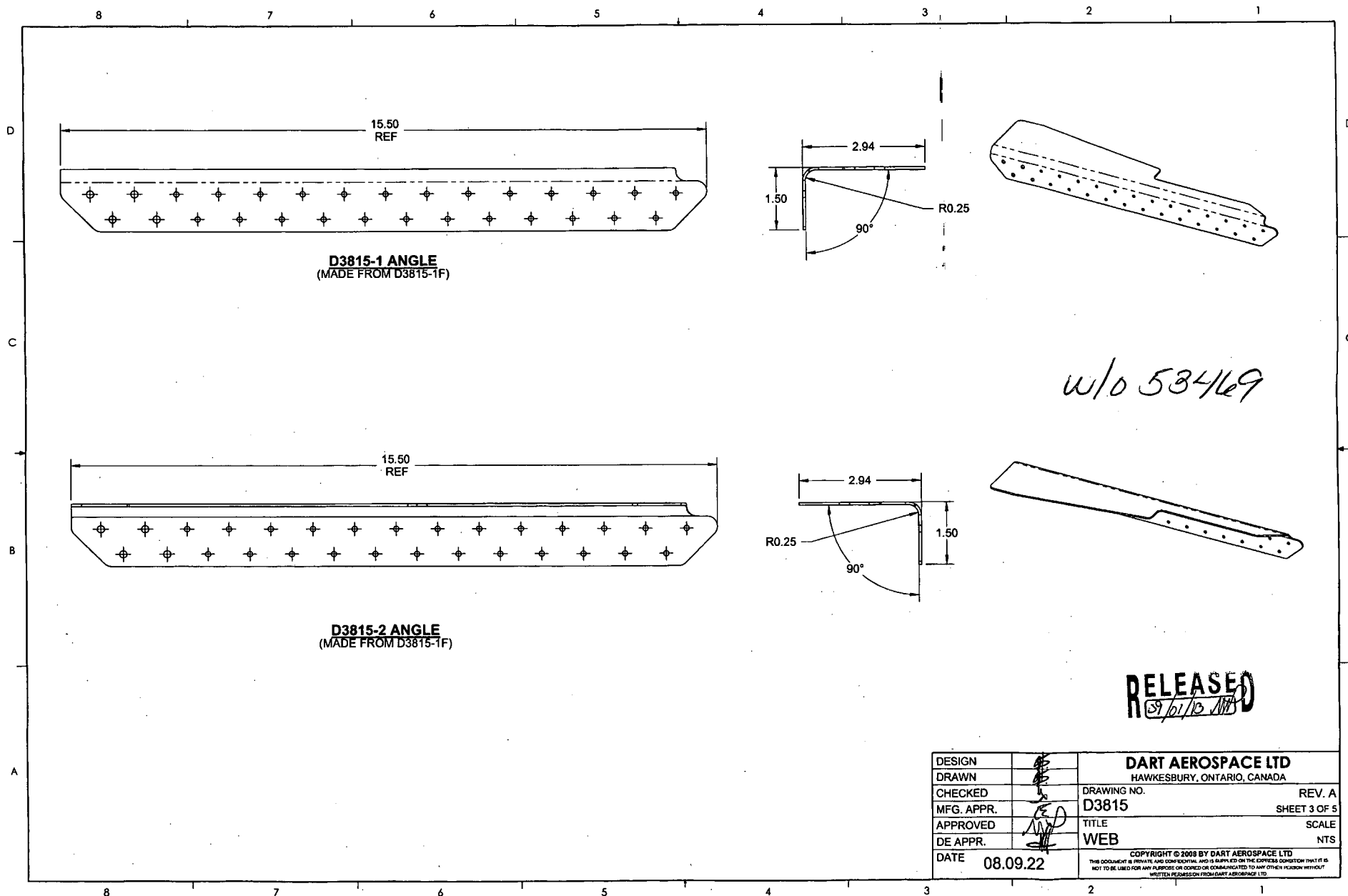
D3815-1F FLAT PATTERN

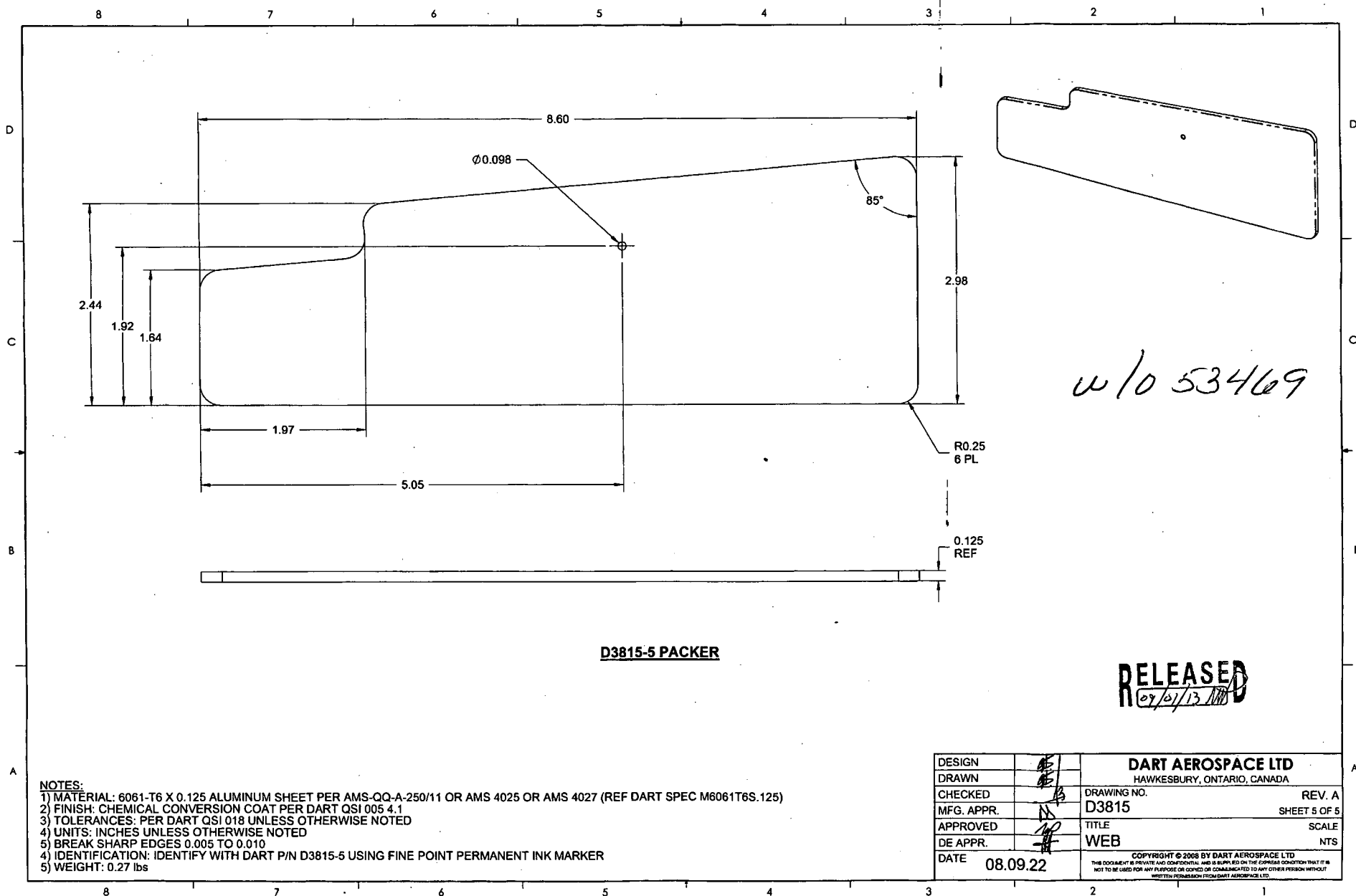
RELEASED
09/13/13

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs